

Work Order ID 61322

Wednesday, August 18, 2010 8:06:35 AM

Page 1

Item ID: D3413-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Ring

Start Date: 8/18/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 8/24/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: mk Date: 10-8-18

Tooling:

Date:

Run Start

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3413	Rev A

100

0.00



Waterjet

FLOW WATERJET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

304 250x4"

10-8-19

(24)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-8-19

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Sidney

count
(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

⇒ m.l 10/08/24

Quality Control

S10102/24

count
x24

Memo

Powder Coating

START TIME:

400° ☐ FINISH TIME:

□OVEN TEMPERATURE:

10025

ml 18 08 25 22/1

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=7M

10/08/25

x 24

0

170

Identify as per dwg & Stock Location: 473

0.00



Packaging

Memo

0.00

Packaging

10/8/25 242 SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/26

CL10/8/26

Dart Aerospace Ltd

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Picklist Print

Wednesday, August 18, 2010 8:06:34 AM

Page 1

Work Order ID: 61322

Parent Item: D3413-1

Parent Item Name: Ring



Start Date: 8/18/2010

Required Date: 8/24/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A ☐ 05.09.13 ☐ New issue ☐ KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000 		Purchased	No			100	f	9.0000	0.25	5.263158	6.	1310-8-19	

304 BAR .250 x 4.00

Location

Loc Qty

Loc Code

MAT53

9

113084

9

113084

24

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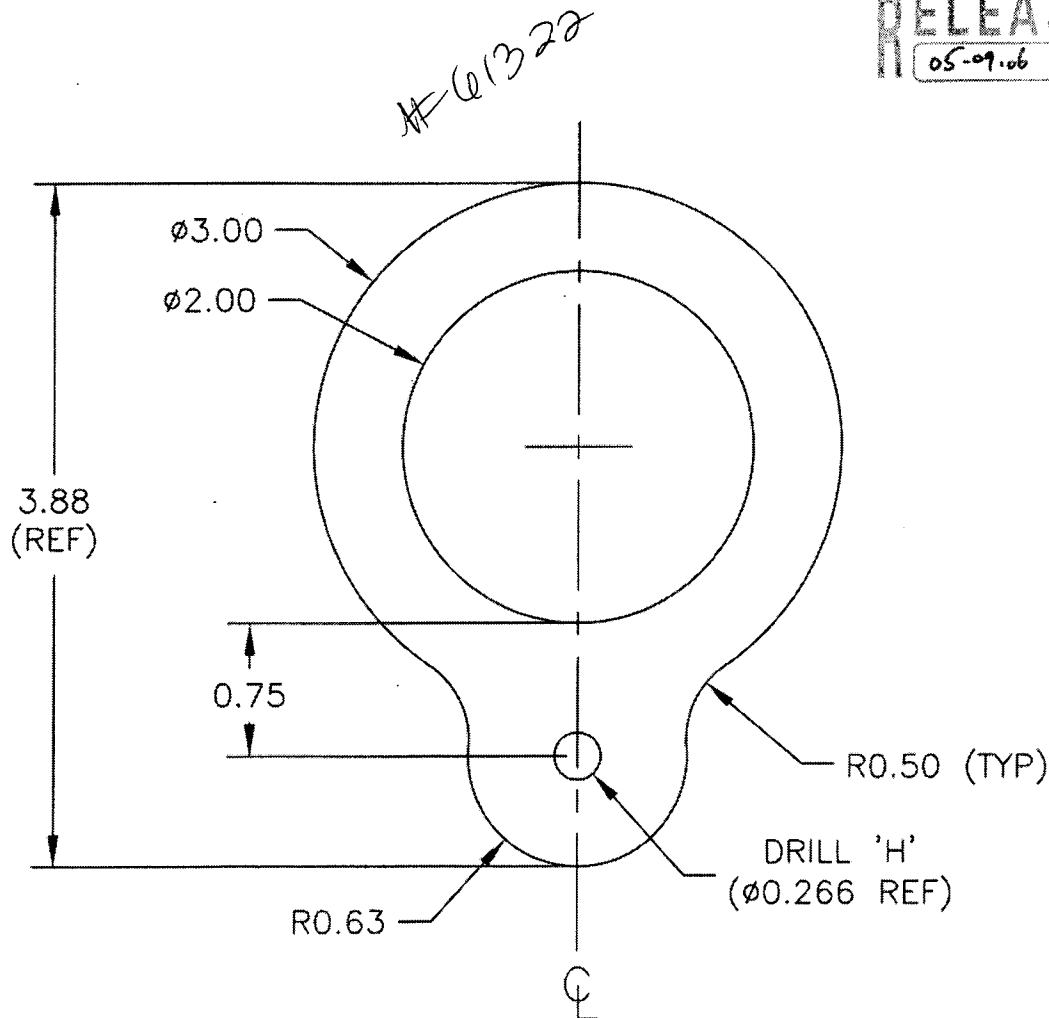
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*

**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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